GLAST		DCN No. 7650-DCN-0043-01					
CHANGE TITLE: Updates To Cal Pem Mechanical Structure Assembly Drawing Internal External							
ORIGINATOR:	Paul Dizon		DATE:	26-Apr-04	NEXT ASSY: N/A		
DOC or DWG NUMBER		TITLE			AFFECTED REV.	NEW REV.	
LAT-DS-01230		CAL PEM Mechanical Structure Assembly			02	03	

CHANGE DESCRIPTION:

1) Added Item 8 to the List of Materials table:

REQD: AR ITEM: 8

PART NO: NSN-8030-00-163-5792

DESCRIPTION: VIBRATITE THREAD LOCK ADHESIVE

- 2) Modified all symmetry tolerance from 0.2 mm to 0.4 mm (page 2, Zone B-3 and Zone C-2)
- 3 Modified perpendicularity tolerance from 0.1 mm to 0.2 mm (page 2, Zone B-3)

REASON FOR CHANGE:

Thread lock adhesive is required to secure the Close-Out Plate Nuts. Assembly of the FMA PEM Mechanical Structure revealed that tolerances can be opened to make assembly of future structure easier. Increasing these tolerances does not violate the stay clear zone specified in the IDD (LAT-DS-00233-07).

DISPOSITION OF HARDWARE:

No hardware affected

Serial numbers affected: 102 - 116 Effective date: 26-Apr-04

	Use as is	Retest	Rework	Scrap	Other/Comment
Raw material					
Parts in process					No Affect
Assemblies					

APPROVALS	DATE	OTHER APPROVALS (specify):	DATE
ORIGINATOR: P. Dizon	29-Apr-04	:	
SUBSYSTEM MANAGER: P. Dizon	29-Apr-04	:	
PROJECT MANAGER: W.C. Raynor	29-Apr-04	:	
QUAL ASSUR. MANAGER: J. W. Lee	29-Apr-04	:	
CONFIGURED AND RELEASED: P. Sandora	29-Apr-04		



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DESCRIPTION NOTES: UNLESS OTHERWISE SPECIFIED: I. ASSEMBLE IAW ASSEMBLY PROCEDURE LAT-PS-01231 2. TORQUE SPECIFICATION:
MJ4 X 0.7 = 4Nm
MJ5 X 0.8 = 5.5 Nm AR 8 NSN-8030-00-163-5792 VIBRATITE THREAD, LOCK ADHESIVE SCREW, CAP, SCH, SS, M5 X 8, I2L A286 SCREW, CAP, SCH, SS, M4 X 0.7, 8L A286 25 5 722-95-029-050-0.75B WASHER, FLAT, SS, M5, 16 4 722-95-029-040-0.4B WASHER, FLAT, SS, M4, TOP FRAME COMPOSITE STRUCTURE, BASE PLATE/PIN ASSEMBLY, LAT-DS-02848 LAT-DS-01230 CAL MODULE, MECHANICAL STRUCTURE ____ DESCRIPTION PART NO. MATERIAL SPEC LIST OF MATERIAL UNLESS OTHERWISE SPECIFIED: ALL DIMENSION ARE IN INCHES INIT DATE NAME **MASTER** SPACE SCIENCES DIVISION NAVAL RESEARCH LABORATORY WASHINGTON, DC **DRAWING** SCALE 0.750 AND APPLY AFTER FINISH DIMENSION TOLERANCES DESIGNER R.BROOKS GLAST-CAL CM DRAWN BY
R. BROOKS 8 4/29/04 .XXX: ±0.005 ANGLE: ±0.5° TITLE FILE COPY V D **4/29/04** FRACTIONS: ±1/16 APPROVED-STRESS MECHANICAL STRUCTURE VD 4/29/04 INTERPRET DRAWING PER ANSI YI4.5M-1982 REMOVE ALL BURRS AND SHARP EDGES R.010 OR CHAMFER MAX THIRD ANGLE PROJECTION TASK NO: WR 4/29/04 MODEL NAME: LAT-DS-01230 .
DRW VERSION: .
PRO/ENGINEER VERSION:200012 CM CLASSIFICATION CAGE CODE SCALE: 1.000 WT APPROX:

REVISION

